



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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SWA3-100
Job Sheet 182750



JL-S #10

8-31

Part No: SWA3-100

Job Qty: 10 ea

Part Name: Upper End - Swa3 Swivel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/31/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA3-100 Rev 15 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/14/18	9/14/18	0.00	0.00	Start Up Machining-3		
100	Bandsaw	10 pcs	9/14/18	9/14/18	0.00	1.00	Bandsaw1		
110	Mori Seiki	10 pcs	9/14/18	9/14/18	0.00	10.00	MORI NLX		
120	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC2		
130	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC8		
140	Packaging	10 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3		
150	QC21-SA	10 Ea	9/14/18	9/14/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks to 6.250"

Descriptions: 110 - 1-Machine as per DWG. FC330 FOLIO REV: AA DWG REV: 15 2-Debur ***Machine engrave S/N number and machine engrave UP arrow***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.000	17-4 SS Round Bar 2.000"	5.2000 ft (.52 ea)	90-Start up Operation	549642

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R2.000	5	6	0

Part Specifications

Specifications could not be found.



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CANADA
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Plex 8/31/18 6:42 AM Dart.lajeunesse.marie

Container No: S108526



Part: SWA3-100

Job No: 182750

Serial No/Batch: S108526

Revision: 15

Inspector:

Exp Date:

Instructions:

Date: 09/07/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

182 750

DART AEROSPACE LTD		Work Order:	182545
Description: upper end SWAS swivel		Part Number:	SW43-100
Inspection Dwg: SW43-100	Rev: 15	Page 1 of 2	

INSPECTION SHEET

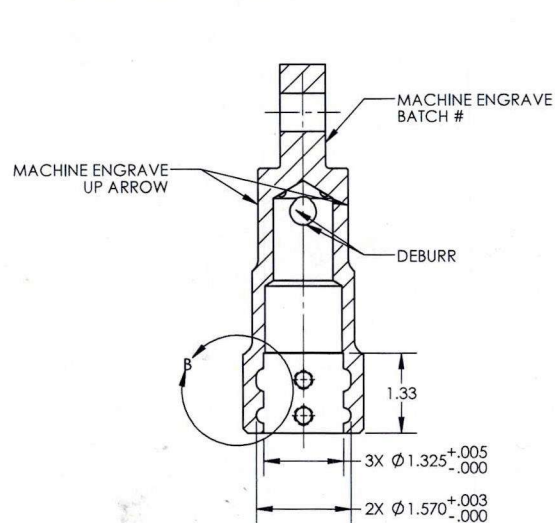
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.33	$\pm .01$	1.325	✓		vern LPI0	
Ø 1.325	$+ .005 / - .000$	1.327			↓	
Ø 1.570	$+ .003 / - .000$	1.571			↓	
R.187	$\pm .005$	.187			Rad gage	
.015 x 45°	$\pm .005 \times .5^\circ$	.015 x 45°			vern LPI0	
.27	$\pm .01$	.271			H.G.	
Ø 1.70	$\pm .01$	1.702			vern LPI0	
Ø 1.50	$\pm .01$	1.502			↓	
Ø .75	$\pm .01$	.750			↓	
45°	$\pm .5^\circ$	45°			Protractor	
6.15	$\pm .01$	6.149			vern LPI0	
2.70	$\pm .01$	2.70			↓	
1.31	$\pm .01$	1.315			↓	
R.25	$\pm .01$	.25			Rad gage	
R.03	$\pm .01$	.03			↓	
Ø .640	$+ .01 / - .000$	.645			vern LPI0	
.81	$\pm .01$	.807				
1.985	$\pm .005$	1.980				
1.28	$+ .01 / - .00$	1.284				
Ø .98	$\pm .01$	.990				
2.46	$\pm .01$	2.465				
3.90	$\pm .01$	3.900				
Ø 2.00	$\pm .01$	1.991				
Ø 1.50	$\pm .01$	1.502				
.75	$+ .00 / - .02$	.740				
1.75	$\pm .01$	1.750				
4.01	$\pm .01$	4.008				
3.68	$\pm .01$	3.670				
.285	$+ .000 / - .001$	.285				

Measured by: [Signature]	Checked by: B.F.	QC Inspector:
Date: 18-09-19	Date: 18-10-07	Date:

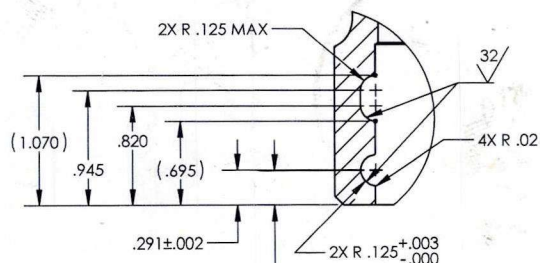
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

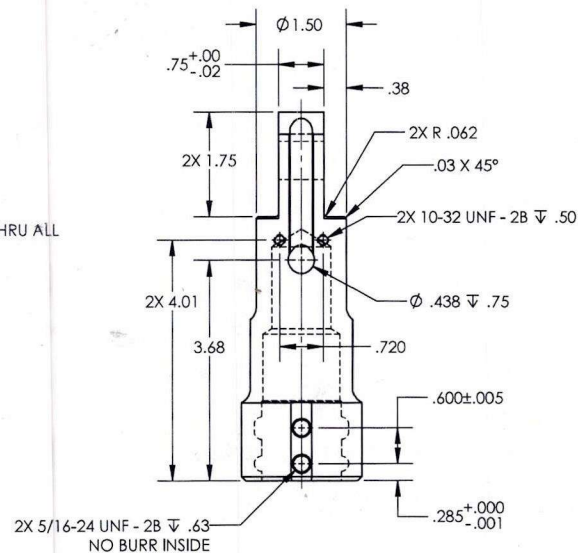
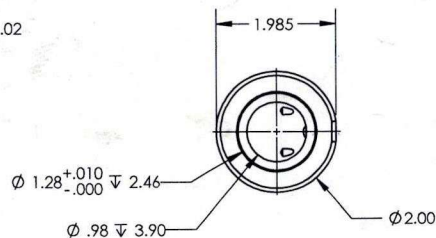
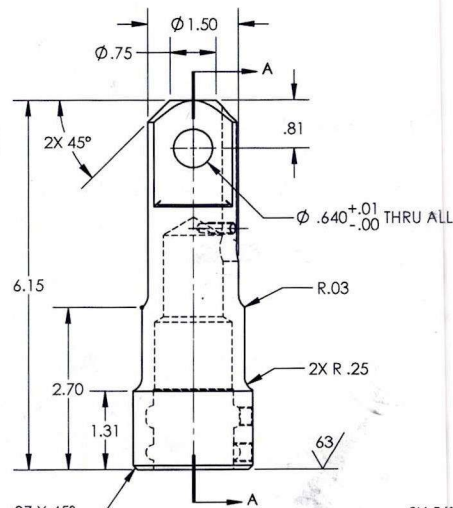
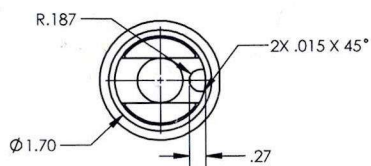
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SECTION A-A



DETAIL B
SCALE 1:1



REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
11		AS DRAWN BY CANAM	8/24/2012	
11A		CHD DIMENSIONS 1.070 & .695 TO REFERENCE, ADDED CENTER DIMENSIONS OF .945 & .820	11/15/2012	JAG
12	15-0270	ADDED UP ARROW NOTE, CHD MATL WAS S.S. 17-4 PH S.S. 17-4, H1150/1075, CHD DIM WAS .75 IS .75 ±.00 ±.02	9/22/2015	DPD JAG
13	16-0083	CHD DIM WAS .375 IS .38, WAS .286 IS .286±.002, WAS .291 IS .291±.002, WAS Ø1.325±.005/-0.000 IS 3X Ø1.325±.005/-0.000, WAS Ø1.570±.003/-0.000 IS 2X Ø1.570±.003/-0.000	7/18/2016	SM JAG
14	17-0036	CHD DIM WAS 1.75 IS 2X 1.75, WAS 2X 5/16-24 UNF - 2B ±.625 NO BURR INSIDE IS 2X 5/16-24 UNF - 2B ±.63 NO BURR INSIDE, WAS 4X R.015 IS 4X .02, ADDED NOTE MACHINE ENGRAVE BATCH #.	2/6/2017	RJC JAG
15	17-0153	CHD DIM WAS Ø1.00 ±.010/-0.000 ±.3.90 IS Ø.98 ±.3.90	6/20/2017	RJC JAG

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA3-100	1	UPPER END	S.S. 17-4, H1150/H1075	

DART AEROSPACE	
TITLE UPPER END SWA3 SWIVEL	
DWG NO. SWA3-100	REV 15
MATERIAL: S.S. 17-4, H1150/H1075	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
FRONT XXX ± .005 FRACTIONS ± 1/8	1. BREAK ALL SHARP EDGES
FINISH XX ± .01 ANGLES ± 5°	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SPEC X ± .1 SURFACES ± 125	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: CANAM	USED ON MODEL
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE: 1:2	DATE: 6/18/2002 SHEET 1 OF 1